

Work Order ID 164964

Friday, August 11, 2017 8:45:11 AM

164964

Page 1

Item ID: D4770-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar Weldment

Start Date: 8/11/2017 Start Qty: 4.00

4

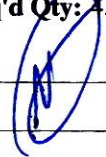
Cust Item ID:

Required Date: 8/21/2017 Req'd Qty: 4.00

4

Customer:

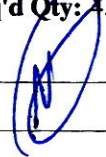
Reference:

Approvals: Process Plan:  Date: AUG 10 2017

Tooling:

Date:

Run Start *NR1*

QC: 

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4770	C
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100

0.00

100

Cold Saw

Memo

0.20

Hyd Mech

1- CUT D4770-5 BLANKS AT 56.25"

4 Q.L 17-08-11

110

Weld per dwg & QSI004 4.5

0.00

110

autoweld 1

Memo

1.20

Automated Welding 1

SEE NOTE 8 FOR SURFACE BUILDUP

1- USE GRINDER TO CHAMFER END AS PER DWG.

FOR AUTOMATED WELDING USE 8259 HARDCOAT
BATCH: M137716

4 Q.L 17-08-11

Work Order ID 164964

Friday, August 11, 2017 8:45:12 AM

164964

Page 3

Item ID: D4770-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar Weldment
Start Date: 8/11/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21 - Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.40							
Quality Control									

44 8/15/17

DAS
21
9-89

DAS
21
9-89

AUG 21 2017

Picklist Print

Friday, August 11, 2017 8:45:11 AM

Page 1

Work Order ID: 164964

164964

Parent Item: D4770-045

D4770-045

Parent Item Name: Bar Weldment

Start Date: 8/11/2017

Required Date: 8/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 17.04.17 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.250x0.500

Purchased

No

100

f

133.3780

4.69

19.74737

M304B0 250x0 500

**

Q.L 17-08-11

304 BAR .250 x .500

Location

Loc Qty

Loc Code

WA002

133.378

m137512

12.13

m137065

8.79

m137172

5.058

m137824

16.55

m138090

60

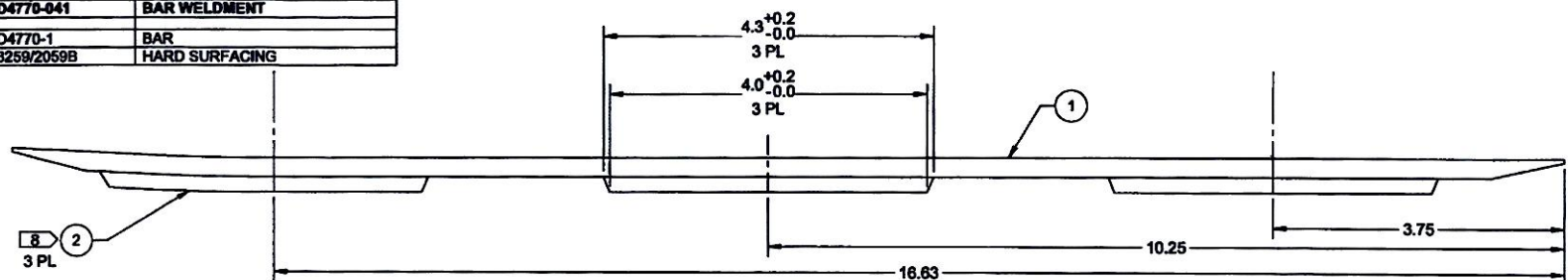
m138160

30.85

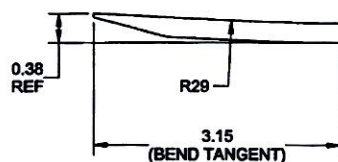
9.2

9.2

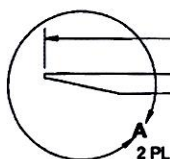
ITEM	QTY	P/N	DESCRIPTION
	X	D4770-041	BAR WELDMENT
1	1	D4770-1	BAR
2	A/R	8259/2059B	HARD SURFACING



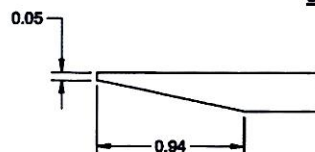
D4770-041 BAR WELDMENT



D4770-1 BAR
(MAKE FROM D4770-1F)



D4770-1F FLAT BAR



DETAIL A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164964
AUG 11 2017

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M30480.250X0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.02 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

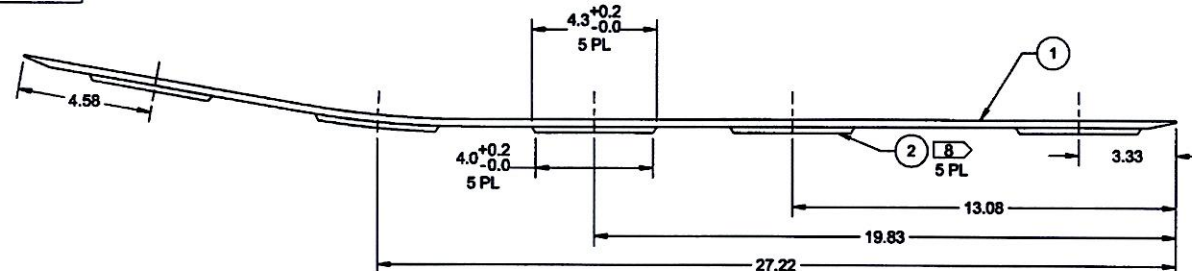
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2017 APR 10
BN 17-33Z

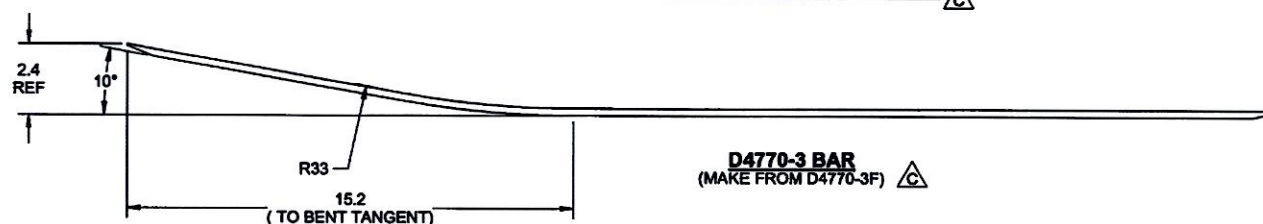
C	ADD -041/-043/-045/-047 WELDMENTS, REMOVE NOTCHES FROM ALL BARS, ADD WELD NOTE 8, DELETE SH 5 REASON: NEW WELD PROCESS	SAD	17.02.14
B	ADDED BEND TO D4770-1 BAR, MINOR DIM CHANGES TO D4770-3 BAR, ADDED SHT 3 AND SHT 5, ADDED D4770-7 BAR	AP	15.04.01
A	NEW RELEASE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	SAD		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BAR	NTS
DATE	17.02.14	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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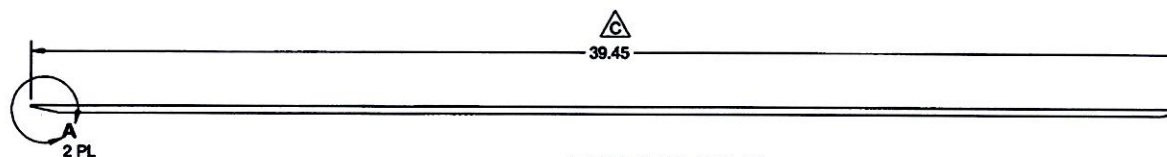
ITEM	QTY	P/N	DESCRIPTION
	X	D4770-043	BAR WELDMENT
1	1	D4770-3	BAR
2	A/R	8259/2059B	HARD SURFACING



D4770-043 BAR WELDMENT



D4770-3 BAR
(MAKE FROM D4770-3F)



D4770-3F FLAT BAR
(FLAT PATTERN)

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.95 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

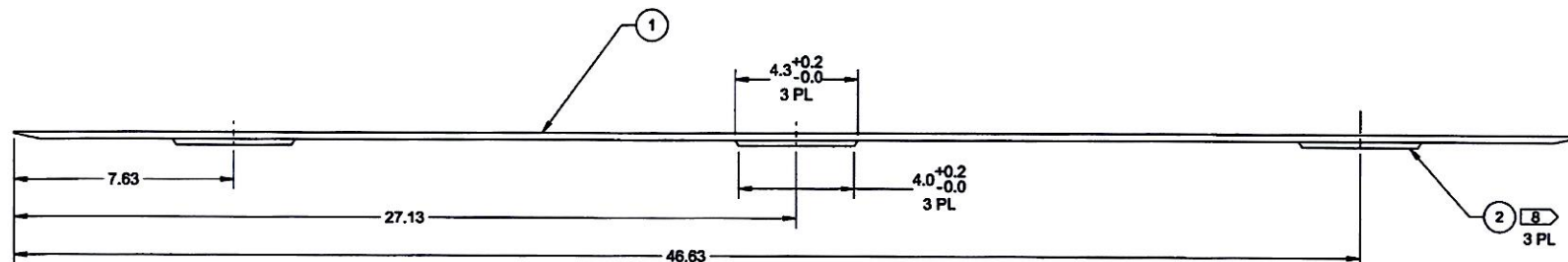
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2017 APR 10

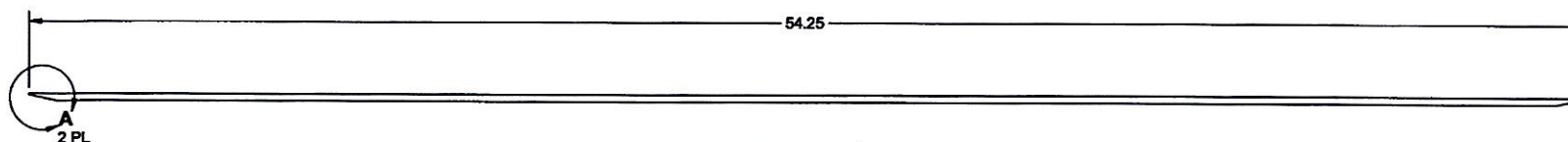
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DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	SAD	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BAR	NTS
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D4770-045	BAR WELDMENT
1	1	D4770-5	BAR
2	A/R	8259/2059B	HARD SURFACING



D4770-045 BAR WELDMENT ⚠



D4770-5 BAR ⚠

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 2.26 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

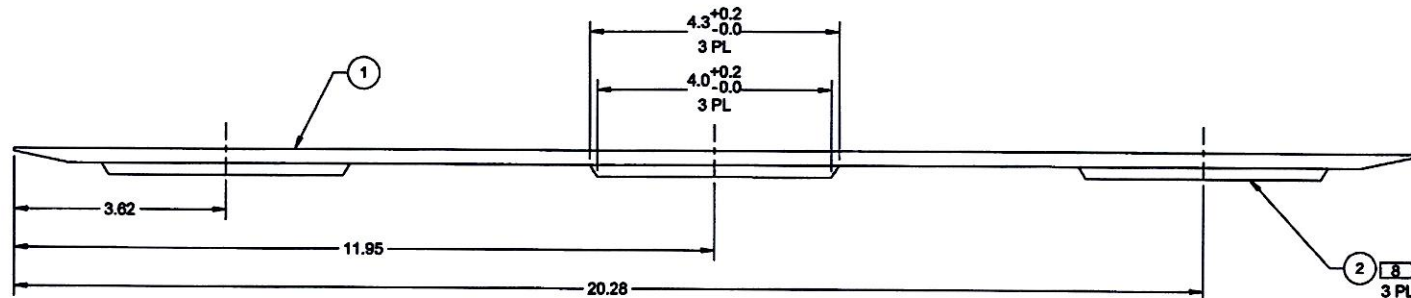
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2017 APR 10 41

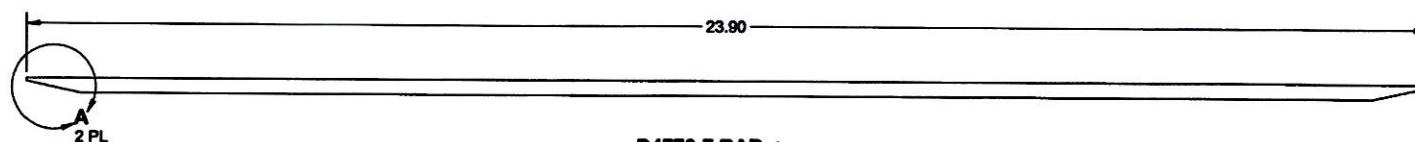
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DESIGN	AP	DART AEROSPACE USA, INC.	
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CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BAR	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D4770-047	BAR WELDMENT
1	1	D4770-7	BAR
2	A/R	8259/2059B	HARD SURFACING



D4770-047 BAR WELDMENT



D4770-7 BAR

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF DART SPEC. M304B0.250X0.500

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.17 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

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2017 APR 10

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DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
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CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4770	SHEET 4 OF 4
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